

Need this WC

Work Order ID 57256

March 31, 2010 10:34:06 AM



Page 1

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 31/03/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: *PF*

Date: 10-3-31 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3537	Rev C
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100	0.00	FLOW WATER JET	<i>FB 10-4-7</i>
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Waterjet	Memo	0.00	<i>FB 10-4-7</i>
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FLOW CNC Waterjet	1-Cut as per Dwg D3537 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary	<i>(36) 663</i>	<i>(36)</i>
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110	QC2- Inspect parts off machine FAI/FAIB	0.00	<i>FB 10-4-7</i>
-----	---	------	------------------

QC	Memo	0.00	<i>FB 10-4-7</i>
----	------	------	------------------

Quality Control	QC8- Inspect parts - second check	0.00	<i>S. Schubert</i>
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120	Memo	0.00	<i>canto X36</i>
-----	------	------	------------------

QC			
----	--	--	--

Quality Control			
-----------------	--	--	--

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57256

March 31, 2010 10:34:06 AM



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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2- Identify as D3537-1

SB 10/04/12

(30)

140



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any
weld that penetrated through Wearpad if necessary

M114373

EL 10-5-12 X36

150



QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

S wlc-112

contro
X36

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Work Order ID 57256

March 31, 2010 10:34:06 AM



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Item ID: D3537-1

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Setup Start



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Item Name: Wearpad

Stop



Start Date: 31/03/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S1012

(cont'd)
X36

170



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

0.00

oven temperature:

START TIME: 7:15AM FINISH TIME: 7:45PM

320°c

X36

6

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

X36 BL 10-5-13

W/O:		WORK ORDER CHANGES						
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Work Order ID 57256

March 31, 2010 10:34:06 AM

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Item Name: Wearpad

Stop



Start Date: 31/03/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

190



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location:

FP-17

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

M 10/05/13

X36 Ø

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/13 HJ

MF
10-5-13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March 31, 2010 10:34:12 AM

Page 1

Work Order ID: 57256



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 31/03/2010

Required Date: 09/04/2010

Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	138.6899	2.2316		B10-4-7	

304/316 Sheet .063

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT20	138.6898737	
106860	8.0295	
111924	25.1689737	
112442	29.8865	
113295	75.6049	113298

(36)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	5725C
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BS</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-4-07	Date:	10/04/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	

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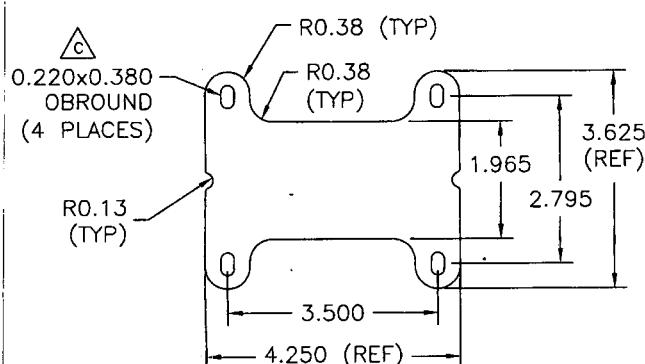
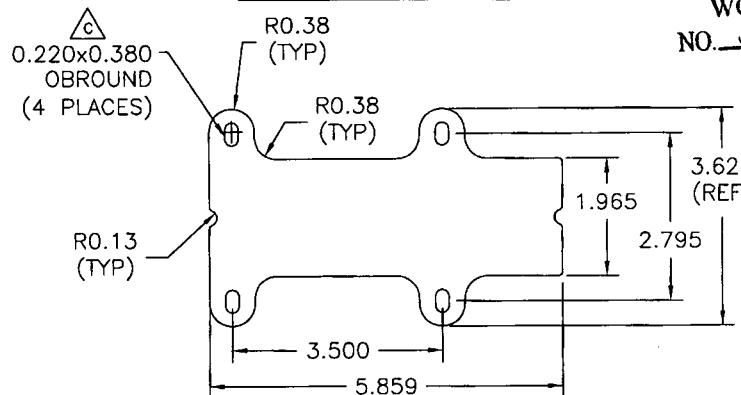
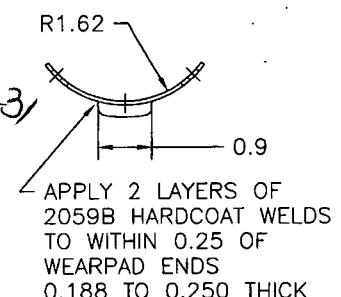
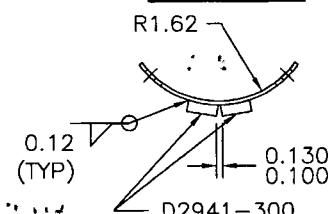
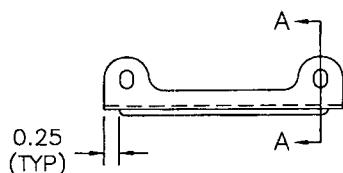
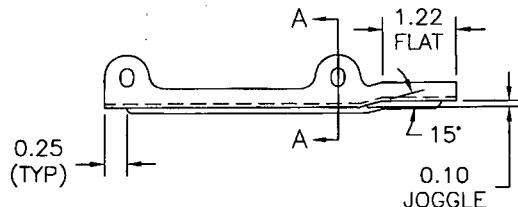
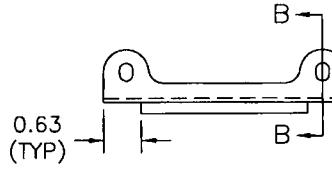
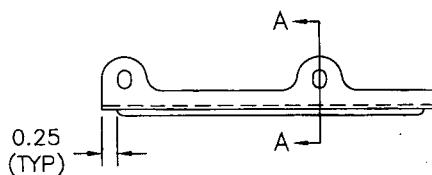
NOTE: Date & initial all entries

S1.

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDERNO. 57256*P10-3-3*D3537-1F FLAT PATTERND3537-3F FLAT PATTERNSECTION A-ASECTION B-BD3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)D3537-1/-3/-5/-7 WEARPAD NOTES

- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- BREAK ALL SHARP CORNERS 0.063 MAX
- WELD PER QSI 004
- FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. REV. C D3537 SHEET 1 OF 1
DATE	07.04.13	TITLE WEARPAD SCALE 1:2

*RELEASED
07.05.03 AM
per E&L
962*

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